

Work Order ID 55223

January 12, 2010 1:27:38 PM



Page 1

Item ID:	D4044-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Center Rib Assembly					
Start Date:	1/12/10	Start Qty:	2.00		Cust Item ID:	
Required Date:	1/25/10	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-1-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4044	PA3	10/01/27							

100		0.00							
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Large Fab		0.00							
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Large Fab	Memo								
	1- Cut tube 60" and remove identification markings -								
	2- Bend tube with manuel pipe bender as per dwg D4044-3 -								
	3- Drill and chamfer holes as per dwg D4044-3 -								
	4- Trim access tube material to finish size as per dwg D4044 -								
	5- weld bushing as per dwg D4044 -								
	A/R S.S. rod Batch: 1109213								
	6- grind welds flush								

110	QC5- Inspect part completeness to step on W/O	0.00							
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QC		0.00							
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Quality Control									
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MATERIAL CERTIFICATE
REQ'D UPON DELIVERY

U 10-01-27

PD 10.01.26 ②

10/01/26

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							AA 10/01/26
130 Packaging Packaging	Identify as per dwg & Stock Location <u>Basket</u> Memo	0.00 0.00							PD 10.01.26
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							BS. Prototype test 10.01-30 mf 10-1-27

POSITIVE RECALL
EFFECTIVE 001.27 AUTH h
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 12, 2010 1:27:44 PM

Work Order ID: 55223



Parent Item: D4044-043



Parent Item Name: Center Rib Assembly


Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1  Bushing		Manufactured	No			100	Each	31.0000	6.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

31

53442

2

54072

29

PD 10.01.26

M304TS0.750W.049

Purchased

No

100

f

48.4054

10.5263



304 SQ Tube .75x.75x.049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

48.4054

103240

1.5816

106604

4.9307

107460

29.2779

109087

12.6152

M113763 PD 10.01.26

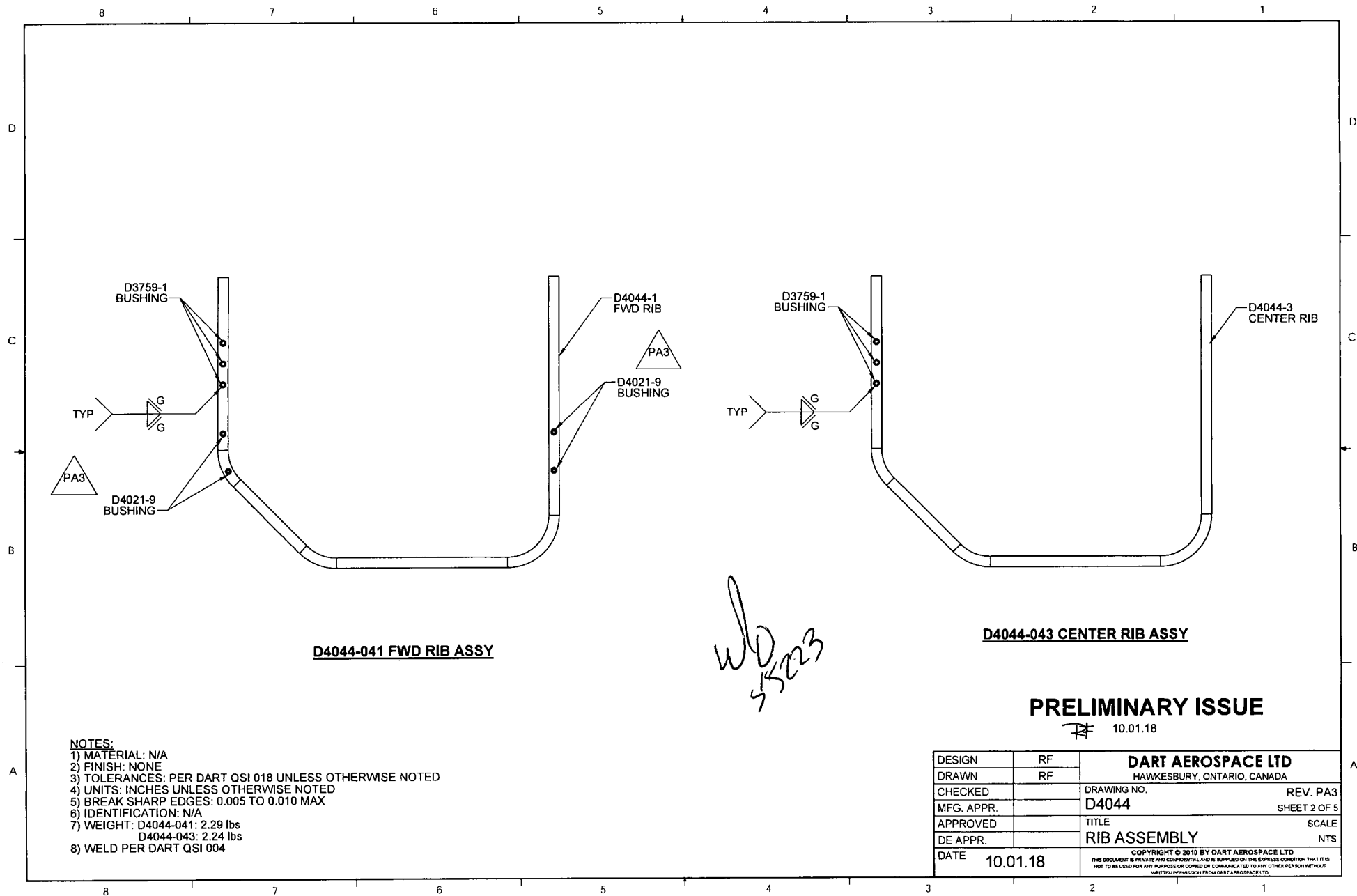
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

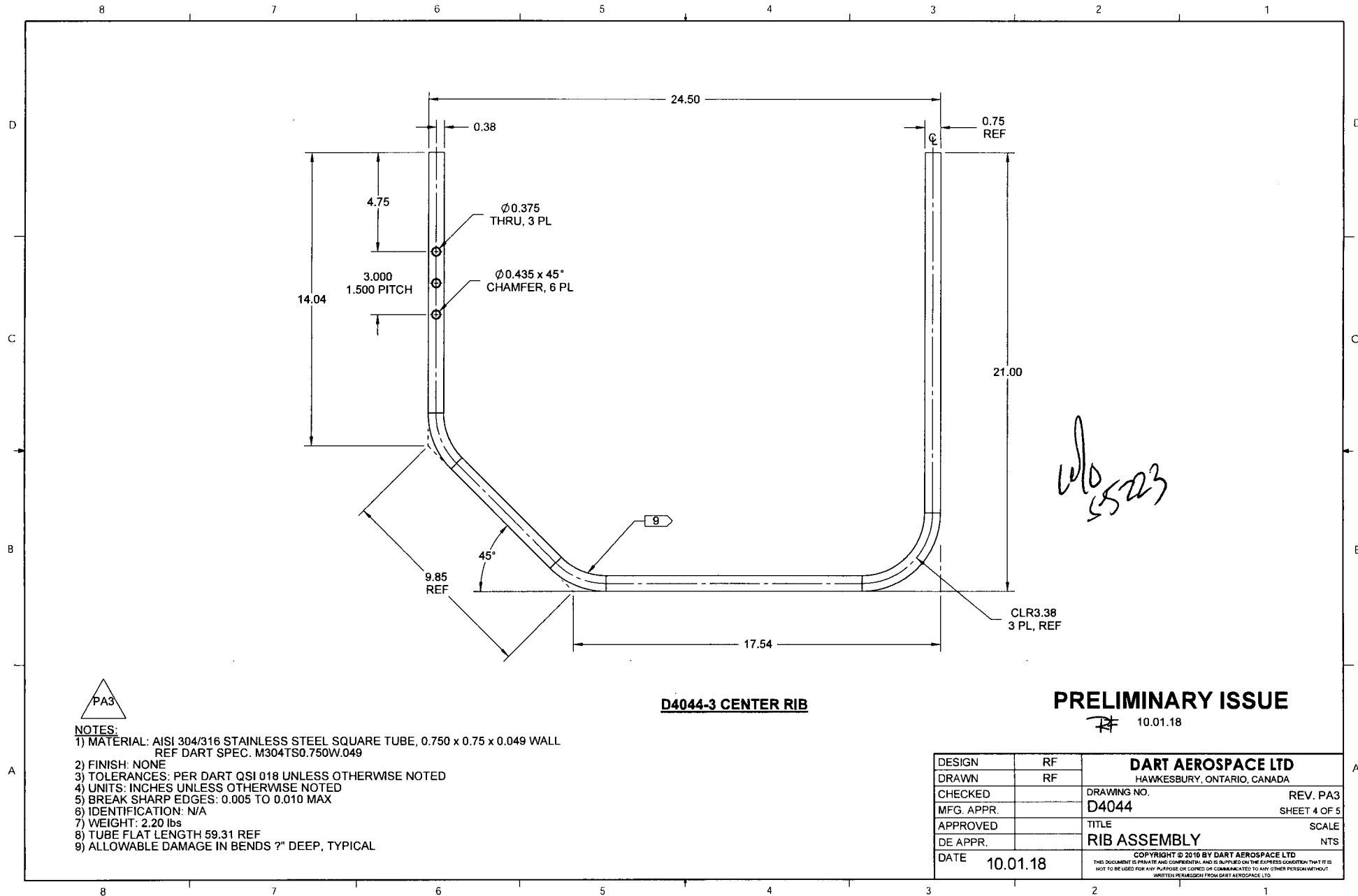
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





Jan 25 10 01:56p

p.3

PHOENIX TUBE COMPANY, INC.
Manufacturer of Stainless Ornamental and Structural Tubing

CERTIFICATION OF TEST

Sold To: MAGNA STAINLESS INC.
5775 RUE KIERAN

SAINT-LAURENT QC H4S
CAN

CUSTOMER ORDER#: PO08691

DATE SHIPPED: 02/23/10

SIZE: 3/4SQ X 18 GA AW

SOURCE: USA D

VENDOR: NAS

Specification:

ASTM A554-08a

NO WELD REPAIR

Ship To: MAGNA STAINLESS INC.
5775 RUE KIERAN

SAINT-LAURENT QC H4S
CAN

Phone# 3391211

Ext:

ORDER#: 209402

QTY SHIPPED: 300.0

GRADE: 304

WELD: HF

HEAT#: 3DK8

TEST REPORT#: TR007424

Report Date: 11/28/07

WELDED / MILL-FINISH

OK P 10.01.26

PO08691

MERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY
OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION.

Chemical Analysis

C	MN	P	S	SI	CR	NI	MO	CU	CO	N2
.058	1.564	.028	.015	.267	18.363	8.14	.256	.298	0	.042

Physical Analysis

Hardness	YIELD		TENSILE		OTHER	
	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 86	49780	0	99490	0	54.1	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.
PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.

Melted & Manufactured in the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY:

Janet L. Laro

1185 WIN DR, BETHLEHEM, PA., 18017 - (610) 865-5337

FAX NUMBER: 610-865-4073

Sq. mill finish